

# Work Order ID 86101

\*86101\*

Page 1

Item ID: D3245-11

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Gasket 9.01

Stop \*NS2\*

Start Date: 20/06/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3245

Rev C

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

10 0 Jm 12-6-28

FLOW CNC Waterjet

1-Cut as per Dwg D3245Dwg Rev: C Prog Rev: C 2-Deburr  
if necessary

Gasket - Durablast

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

10 0 Jm 12-6-28

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

Silberberg

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86101****\*86101\***

Page 2

June-20-12 2:50:13 PM

Item ID: D3245-11

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Gasket 9.01

Start Date: 20/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Memo

*232A*

0.00

*10**12/06/29 JB*

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*12/7/3 JB**MF  
12-06-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

June-20-12 2:50:16 PM

Page 1

Work Order ID: 86101

\*86101\*

Parent Item: D3245-11

\*D3245-11\*

Parent Item Name: Gasket 9.01

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP B04.12.06Made in-houseKJ/JLM

IPP Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3245		Manufactured	No			100	Each	21.0500	0.0438	0.461053			
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\*D3245\*

\*\*

Gasket

Jun 12-6-28

## Location

## Loc Qty

## Loc Code

MAT052

21.05

77224

21.05

77224

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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SUBJECT TO AMENDMENT

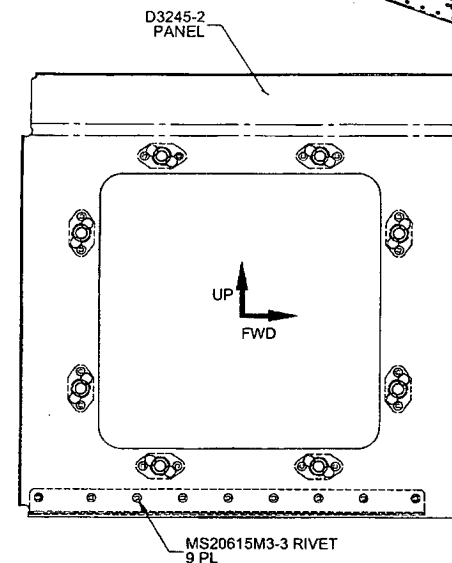
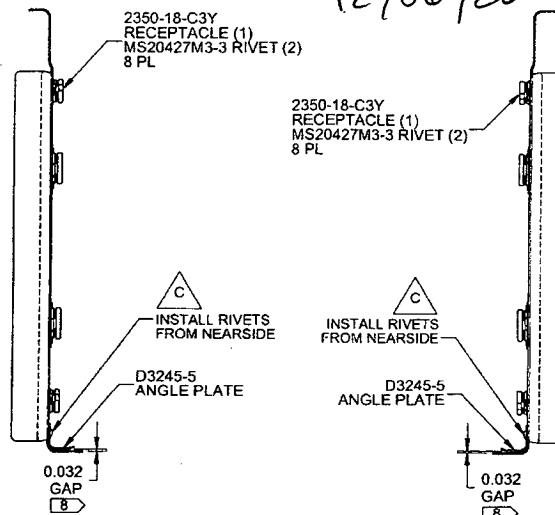
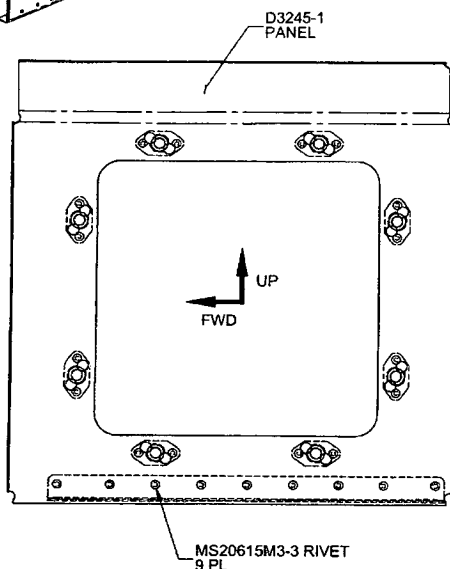
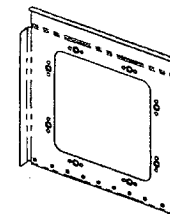
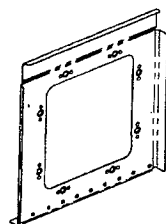
WITHOUT NOTICE  
WORK ORDER

NO. 0601 MCT

12/06/20

D3245-041 ACCESS PANEL ASSY (LH)

D3245-042 ACCESS PANEL ASSY (RH)



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSY (LH)
	X	D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.83 lbs
- 8) TEMPORARILY INSERT A 0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL

C	ADDED NOTE 8, SHEET 1. SPECIFIED RIVET ORIENTATION (B4-1, B5-1). CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2). HOLE SIZE WAS 0.098, 9 PLACES (D6-6). HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-165	RP	12.04.11
B	REMOVE Ø0.204 HOLES FROM D3245-1/1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	MB		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.11		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3245</b>	REV. C SHEET 1 OF 7
TITLE <b>ACCESS PANEL ASSY</b>	
SCALE NTS	
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2012-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3245-3 DOOR

2351-20-012-C3Y STUD  
127H-35 GROMMET  
8 PL8.00  
REF

8.00 REF

D3245-7 GASKET  
REFINSTALL D3245-7  
GASKET ON THIS SIDE  
6**D3245-043 DOOR ASSY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

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APPROVED	MB	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

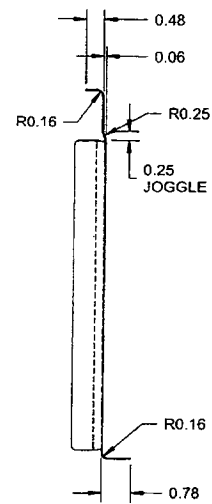
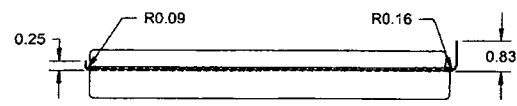
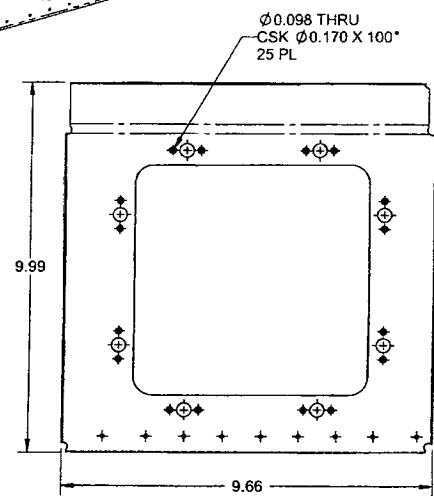
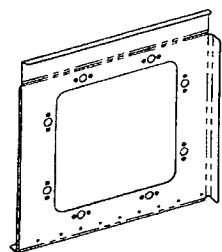
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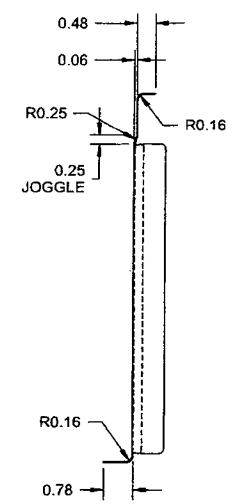
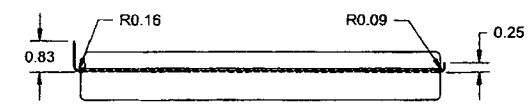
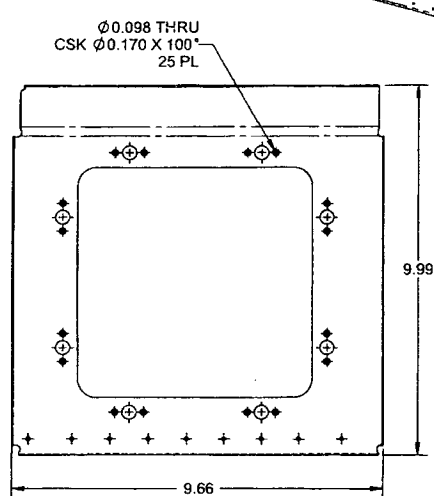
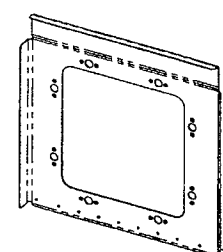
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

86101



**D3245-1 PANEL (LH)**



**D3245-2 PANEL (RH)**

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

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CHECKED	AP	DRAWING NO. <b>D3245</b>	REV. C
MFG. APPR.			SHEET 3 OF 7
APPROVED		TITLE <b>ACCESS PANEL ASSY</b>	SCALE NTS
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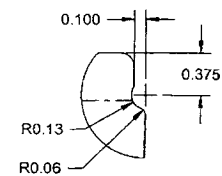
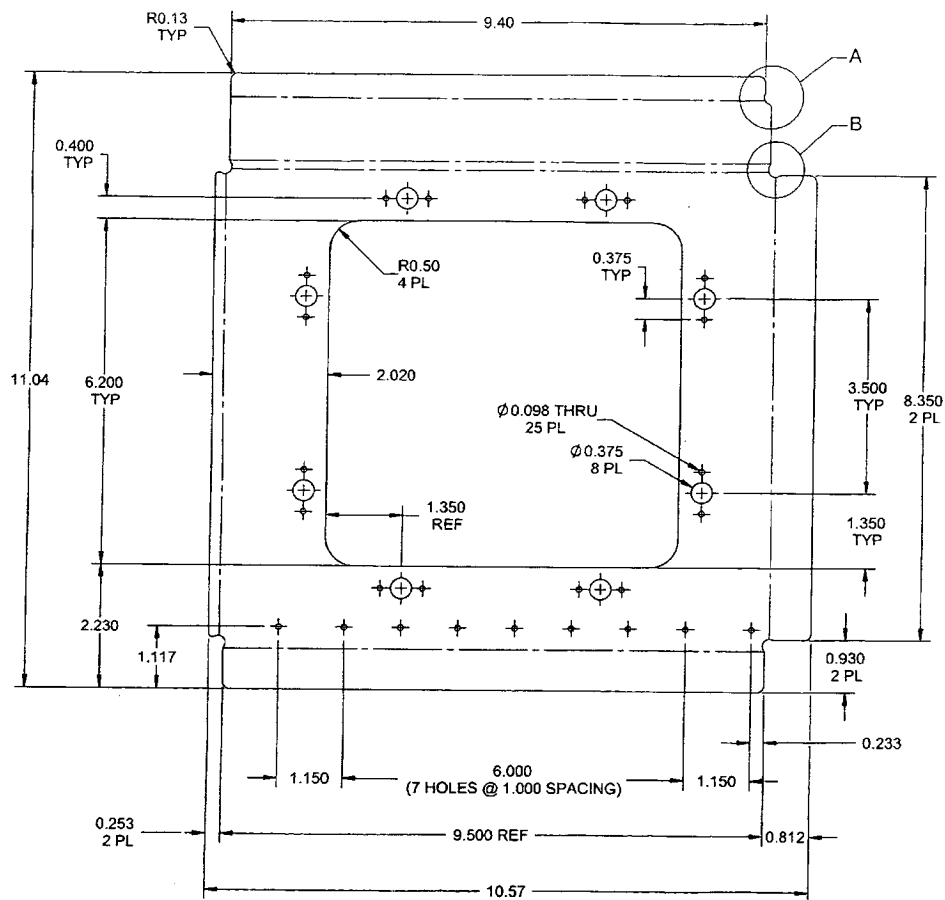
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

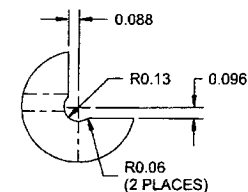
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DETAIL A: RELIEF**  
**SCALE 1:1**



**DETAIL B: RELIEF**  
TYP, 4 PL  
SCALE 1:1

RELEASED  
2012-05-07  
mp

**D3245-1F PANEL FLAT PATTERN**

- NOTES:**  
 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-8059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)  
 2) FINISH: NONE  
 3) TOLERANCES PER DART OSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.70 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3245</b>  TITLE <b>ACCESS PANEL ASSY</b>  COPYRIGHT © 2004 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. AND IS TO BE USED AS A CONSTRUCTION TOOL IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. C
DRAWN	MB		SHEET 4 OF 7
CHECKED	<i>MB</i>		SCALE
MFG. APPR.	<i>MB</i>		NTS
APPROVED	<i>MB</i>		
DE APPR.	<i>MB</i>		
DATE	12.04.11		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

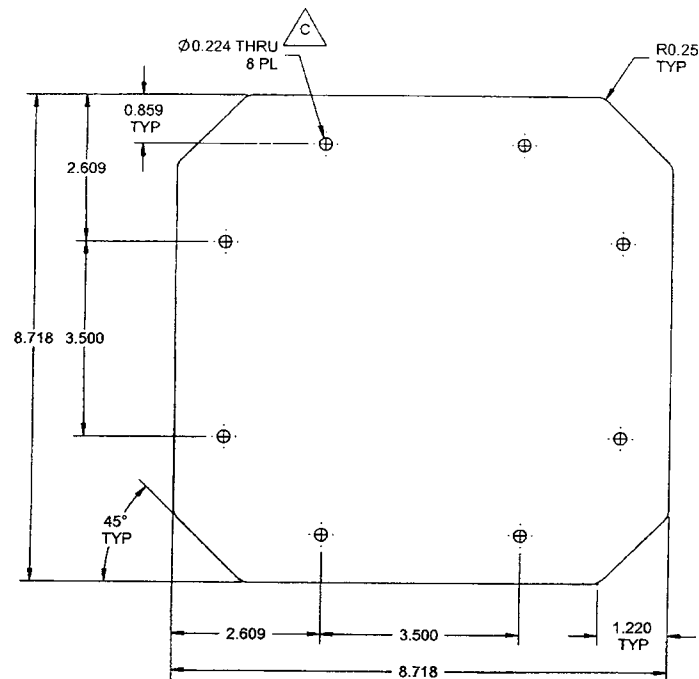
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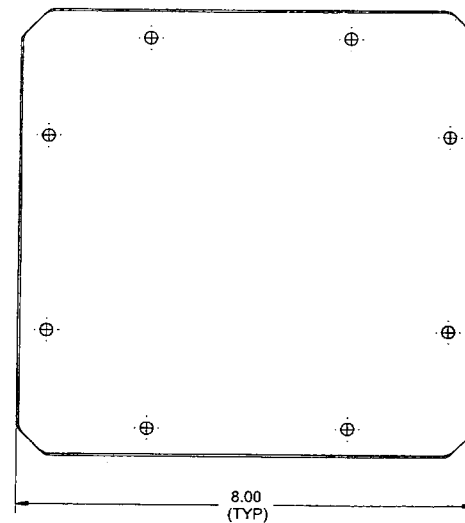
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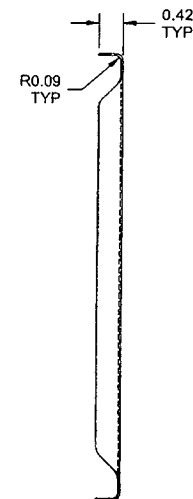
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**D3245-3F DOOR FLAT PATTERN**



**D3245-3 DOOR  
(MADE FROM D3245-3F)**



D

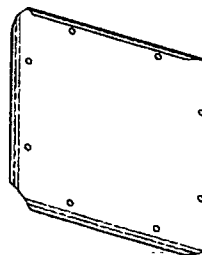
C

B

A

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs



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2012-05-07

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CHECKED	A.P.	DRAWING NO. <b>D3245</b>	REV. C
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DATE	12.04.11		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

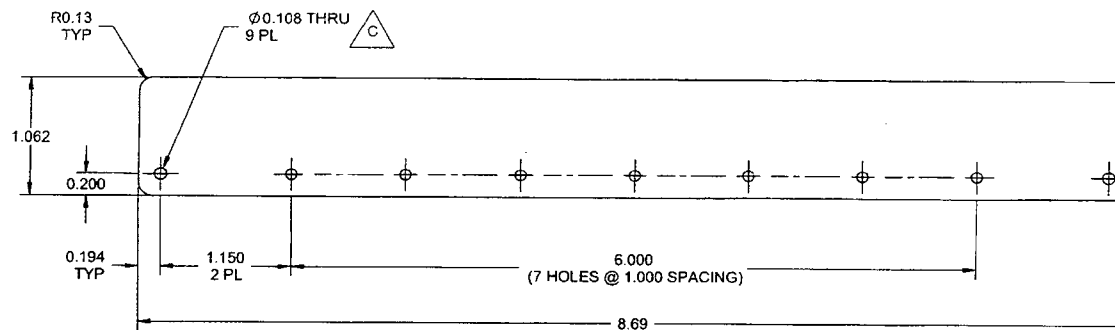
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

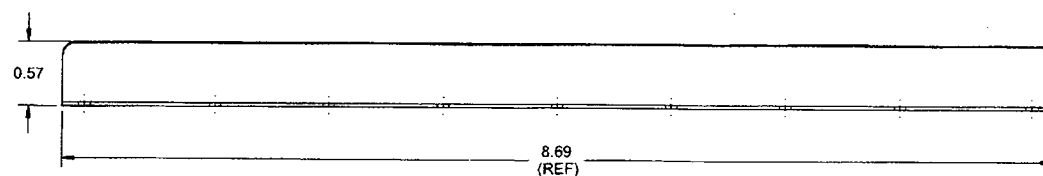
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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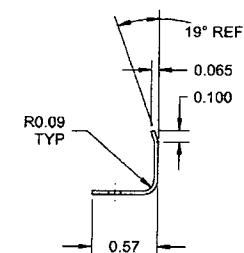




**D3245-5F FLAT PATTERN**



**D3245-5 ANGLE PLATE**  
(MAKE FROM D3245-5F)



DEL. 18 SEP 2012 - 07

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AR	DRAWING NO.	REV. C
MFG. APPR.	ED	D3245	SHEET 6 OF 7
APPROVED	AN	TITLE	SCALE
DE APPR.	AN	<b>ACCESS PANEL ASSY</b>	
DATE	12.04.11	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

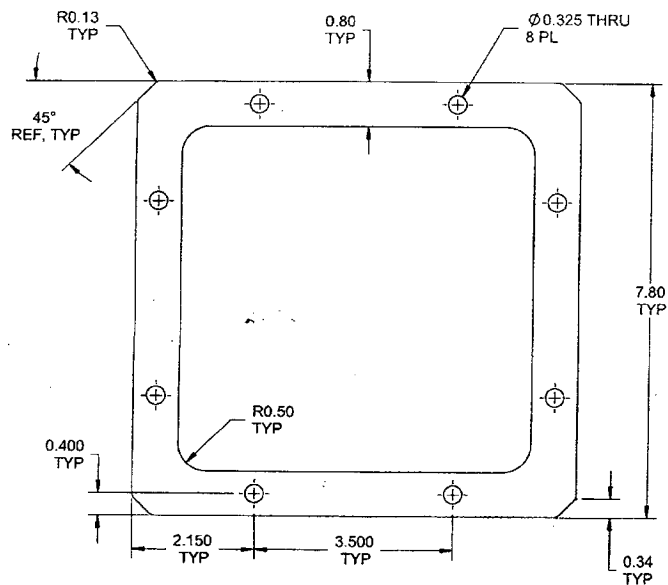
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

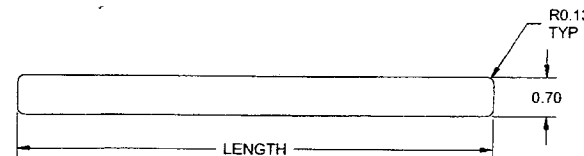
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

86101



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**NOTES:**

- 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK  
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232  
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

2012-05-07

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	E	D3245	SHEET 7 OF 7
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ACCESS PANEL ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

